

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001822**Date Inspected:** 24-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Or.**CWI Name:** Steve Williams**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge K Pipe Beam (62F)**Summary of Items Observed:**

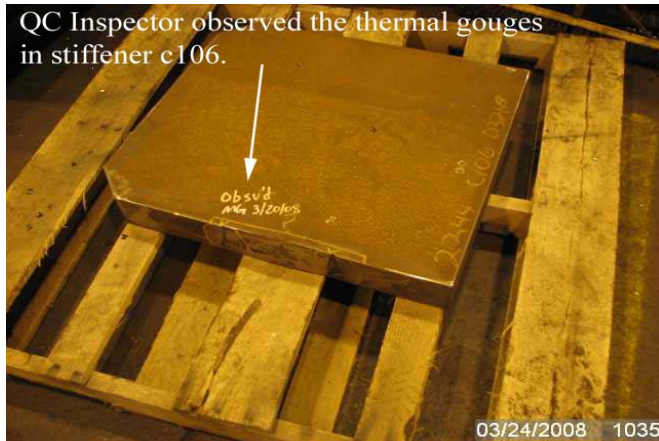
On this date, Caltrans Quality Assurance Inspector (QA) Danny C. White (B89) was present at Oregon Iron Works (OIW) for the purpose of monitoring fabrication operations of the Hinge K Pipe Beam at the OIW fabrication and welding shop in Clackamas, Oregon.

The QA Inspector observed that OIW Quality Control (QC) Inspector Mr. Mike Gregson acknowledged and initialed stiffener c106 which exhibits thermal gouges mentioned in TL6031 report dated 3/20/2008.

During his shift the QA Inspector performed random observations in the fabrication and machine shops at OIW. The QA Inspector observed welding operators and machinists are performing bevel and sizing operations on stiffener plates as well as pipe components by utilizing automatic track type torches and 30 foot planer mill in the fabrication shop (Bay #1) and a vertical turret lathe (VTL) in the machine shop (Bay #5). The QA Inspector observed that OIW has drilled and tapped holes in components marked a106.

WELDING INSPECTION REPORT

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Summary of Conversations:

The QA Inspector later met with Mr. Gregson in person and Mr. Gregson informed the QA Inspector that welding repairs will not be performed on this job prior to acceptance of Welding Quality Control Plan (WQCP), Procedure Qualification Record (PQR) tests and Welding Procedure Specification (WPS's).

The QA Inspector was informed By OIW Welding Engineer Mr. Greg Roberts that (2) reduced section tension specimens which were cut from OIW-PQR-025 and (2) specimens of OIW-PQR-027 are at PSI Incorporated and ready for machining. See TL-6034 created this date for additional information.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	White,Danny
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Quality Assurance Inspector

Reviewed By:	Wright,Mark
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QA Reviewer
